



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

000349

D206-667-207BL
Job Sheet 170521



Part No: D206-667-207BL

Job Qty: 1 ea

Part Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/29/18	1/29/18	0.00	0.00	Start Up Crosstubes-1		DPZ
110	CNC Bend Crosstubes	1 pcs	1/29/18	1/29/18	0.00	4.35	CNC Bend Crosstube		GP/DPZ
120	QC <i>* See attached</i>	1 pcs	1/29/18	1/29/18	0.00	0.00	QC15		38
130	Crosstubes	1 pcs	1/29/18	1/29/18	0.00	2.86	Crosstubes-1		9-89 DPZ1
140	HandFXtube	1 pcs	1/30/18	1/30/18	0.00	0.55	HandFinish5		DAS 38 DPZ1
150	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC7-1		38
160	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC5		9-89 38
170	Outsource	1 pcs	1/30/18	1/30/18			SKY002-VC	1	DAS 13 9-89
180	Packaging	1 pcs	1/30/18	1/30/18	0.00	0.00	Packaging2		13 JAN 7 6 2018
190	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC5		
200	Outsource	1 pcs	1/30/18	1/30/18			ATE003-VC		P0035556
205	Packaging	1 pcs	1/30/18	1/30/18	0.00	0.00	Packaging2		18/01/2018
210	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC14		18/01/2018
220	Crosstubes	1 pcs	1/30/18	1/30/18	0.00	2.86	Crosstubes-1		AB JAN 28 2018
230	Crosstubes	1 pcs	1/31/18	1/31/18	0.00	1.91	Crosstubes-1		AB JAN 28 2018
240	QC	1 pcs	1/31/18	1/31/18	0.00	0.00	QC5		38
250	Packaging	1 pcs	1/31/18	1/31/18	0.00	0.00	Packaging1-2		FEB 01 2018
260	QC	1 pcs	1/31/18	1/31/18	0.00	0.00	QC4		
265	DC	1 pcs	1/31/18	1/31/18	0.00	0.00	DC		
270	Packaging	1 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea	1/31/18	1/31/18	0.00	0.00	QC21		WCS AD FEB 01 2018

Part Op 110 - Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-207

Descriptions: 120 - QC15- Crosstube Dimensional Check

130 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DPZ ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247 ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DPZ ***** 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-247. Note: FWD side has 3X top holes facing inboard. 3- C-sink holes as per dwg D206-667-247. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill only the top (2) holes. Drill & ream the top (2) hole

140 - Crosstubes Chemical Conversion ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

150 - QC7-Inspect Chemical Conversion Coat

160 - QC5- Inspect part completeness to step on W/O

D206-667-207BL/170521/5034532

Job No.: 170521
01/23/18

**Start up
CHG002**

D206-667-207BL
 S034532
 Right 206L / L1 / L3 / L4, Blue
 Operator
 Job

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

170 - Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Receive & Inspect for Damage & Mat'l Certs *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

190 - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure results are as per Dwg D206-667-247

200 - ISSUE PO 33854 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE 103888 Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

205 - Receive & Inspect for Damage & Mat'l Certs

210 - QC14- Inspect Spray Paint Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

220 - 1-Install nut plates as per Dwg D206-667-247.

230 - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: 138708 exp 5/18 3- Torque bolts as per dwg 18-1-28/18-1-31

240 - QC5- Inspect part completeness to step on W/O ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

265 - Document Control Photocopy bluefile and create labels as per PPP D206-667-207 chg 002

270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-667-207 Location: _____ PPP Rev: _____

280 - QC21- Final Inspection - Work Order Release

Job Allocations

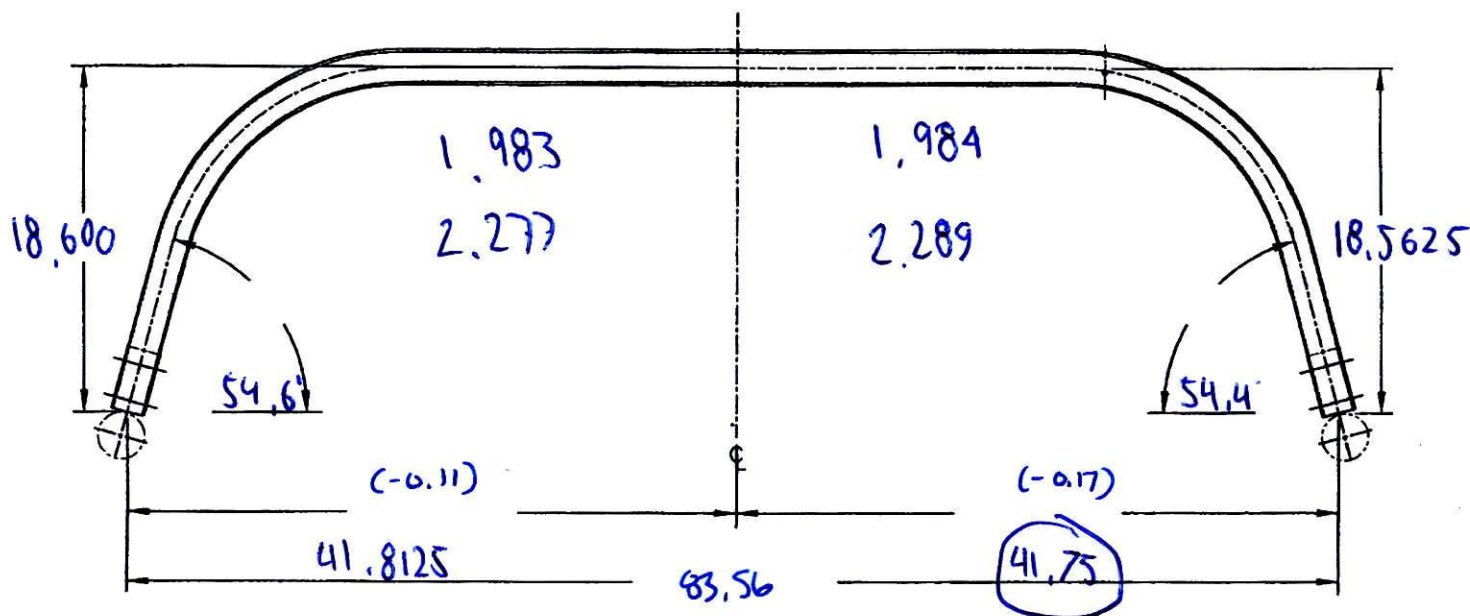
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation <u>5012257</u>	D206-667-247TRN	1	9	0	0
220-Crosstubes <u>168213-A</u>	D2873-043 <u>5034892</u>	②	1	0	0
	D2873-045 <u>5018818</u>	②	27	0	0
	MS20601-AD4W10 <u>5000553</u>	①④	223	0	0
230-Crosstubes	D2892-1 <u>5033175</u>	②	0	0	0
	D3595-063-450 <u>5033985</u>	①	23	0	0
	MS21920-22 <u>5013763</u>	④	126	0	0
250-Packaging	AN5-10A	10	317	0	0
	AN5-32A	4	154	0	0
	AN5-34A	4	121	0	0
	MS21042L5	4	704	0	0
	NAS1149D0563J	18	1,191	0	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order:	170521
Description: Crosstube Mid Aft (206L)		Part Number:	D206-667-207
Inspection Dwg: D206-667-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	13	15
Crushing	6.9%	7.1%
Comments		
Acceptable per DR-1055 4/18/22		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D206-667-247 SHEET 1 OF 4

TITLE SCALE
CROSSTUBE ASS'Y (206L MID AFT) NTS

DATE 10.12.23

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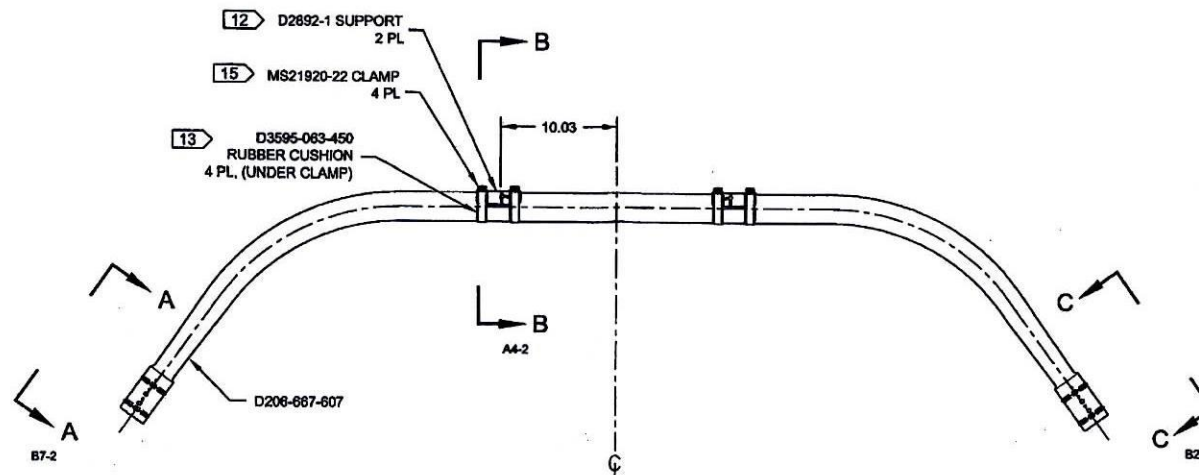
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BCO #11-615
11.07.28

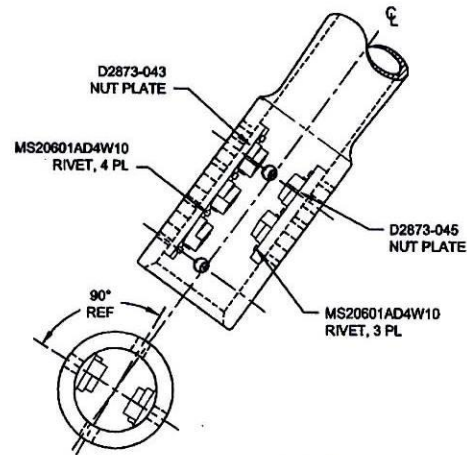
UNDER REVIEW

RELEASED
2011-05-24

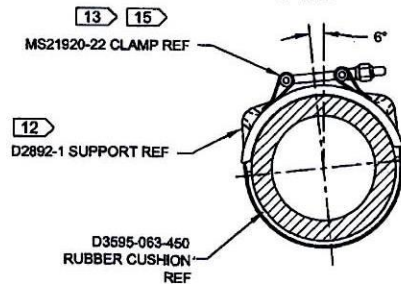
8 7 6 5 4 3 2 1



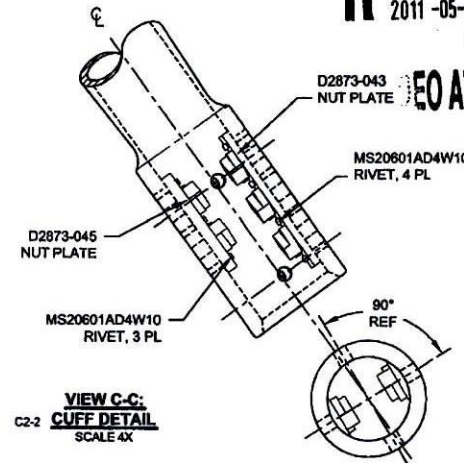
D206-667-247
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



VIEW A-A:
CUFF DETAIL
SCALE 4X



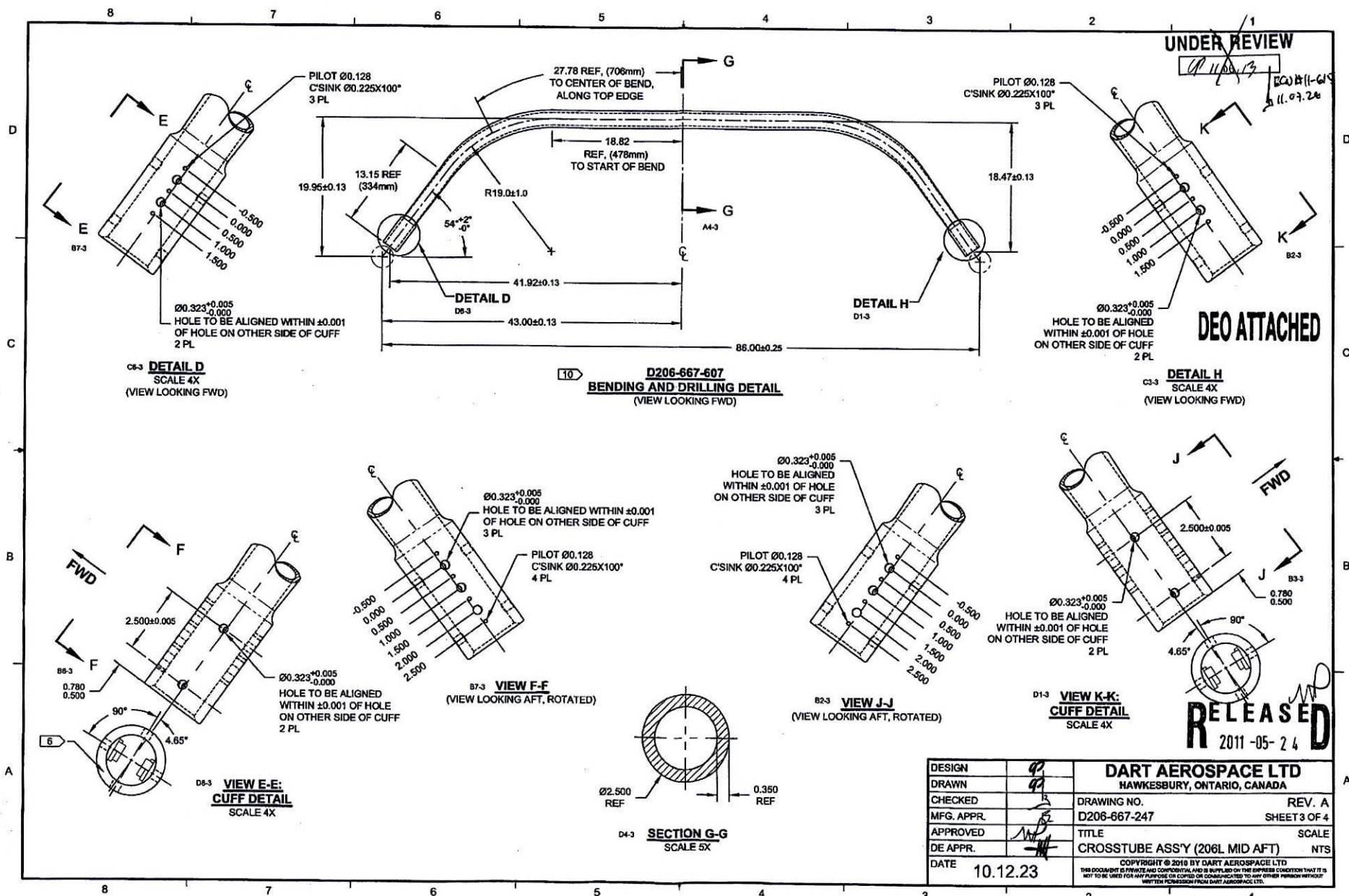
SECTION B-B
SCALE 5X



VIEW C-C:
CUFF DETAIL
SCALE 4X

DESIGN	42	DART AEROSPACE LTD	
DRAWN	42	HAWKESBURY, ONTARIO, CANADA	
CHECKED	42	DRAWING NO.	REV. A
MFG. APPR.	42	D206-667-247	SHEET 2 OF 4
APPROVED	42	TITLE	SCALE
DE APPR.	42	CROSSTUBE ASS'Y (206L MID AFT)	NTS
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8 7 6 5 4 3 2 1



DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. A
MFG. APPR.	13	D206-667-247	SHEET 3 OF 4
APPROVED	13	TITLE	SCALE
DE APPR.	13	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DRAWING NO. D206-667-247	TITLE CROSSTUBE ASS'Y (206L MID AFT)	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-247-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>9P</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>KS</i>	APPROVED <i>JMD</i>		DE APPR. <i>#</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -247	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**QA Closed: 18/1/22 Date: **FEB 12 2018**Work Order update only ☐

Work Order: <u>170521</u> Part No. <u>DZ06-667-202R</u> NCR No. <u>18-6770</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☒ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐									
Date: <u>18/1/22</u>		Step #: <u>110</u>		QTY Effective: <u>①</u>		MRB (QSI042) Approval DAS 12 9-89 <u>18/1/22</u>							
Description Work Order Deviation <u>Tube is bent narrow. One width is -0.17 below nominal. Total width is -0.28 below nominal.</u>				Disposition <u>Acceptable. will not cause fit issue.</u>		Completed By DAS 12 9-89 <u>18/1/22</u> Lead hand / Supervisor Approval Verification <u>ID 18.02.12</u> QC / QA Coordinator Approval <u>PD 18.02.12</u>							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>				Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☒ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☒ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐												
Pressure/Forced ☐ Bending ☒ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐										
OTHER : ☐													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038854**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038854
PO Date: 1/25/18
Due Date: 1/26/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

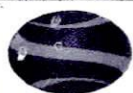
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166582	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
2		D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order 166585	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
3		D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order 170521	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
4	170522	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14

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PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	169676	D135-1027-153	Mid Height Fwd Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
6	169662	D135-1027-253	Mid Height Aft Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
Grand Total:										\$936.86
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

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skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34742	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038854
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

- 1 FWD CROSSTUB , P/N# D135-1027-153 , J/S# 169676 —
- 1 AFT CROSSTUBE , P/N# D135-1027-253 , J/S# 169662 —
- 2 FWD CROSSTUBES , P/N# D206-667-107BL , J/S# 166582 , 166585
- 2 AFT CROSSTUBES , P/N# D206-667-207BL , J/S# 170521 , 170522
- 1 UPPER END , P/N# SWA6A-100
- 1 LOWER END , P/N# SWA6A-200
- 1 BEARING HOUSING , P/N# SWA6A-300
- 2 SEMI RINGS , P/N# SWA6A-500
- 1 COLLAR , P/N# SWA6A-600

Action Taken:		Date:	Initial/Stamp:		
LPI AND MPI C/O IAW ASTM E-1417M-13 & E-1444M-12 DE-MAGNETIZED AS PER ASTM E-144494-A NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142 PARKER PROBE S/N 18163 , CAL. DUE 17/FEB/2018, CARRIER, MPO17874		JAN 25 2018	 		
Description	Location P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		JAN 25 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038886

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038886
PO Date: 1/26/18
Due Date: 1/26/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166582	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
2	166585	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
3	170521	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038886

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
4	170522	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:									\$900.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000349

Tel (613) 632-5200

Containers on Master Unit 000349				
Serial No	Part No	Customer Part No	Status	Quantity
S037828	AN5-10A	AN5-10A	Allocated	10
S037820	AN5-32A		Allocated	4
S037819	AN5-34A		Allocated	4
S037818	MS21042L5	MS21042L5	Allocated	4
S037817	NAS1149D0563J	NAS1149D0563J	Allocated	18